

June 1

Dart Aerospace Ltd.

Date: Thursday, 23/04/2009 1:40:08 PM
 User: Julie Dawson

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	"T" HANDLE ASSEMBLY		
Job Number	47406A		Part Number	D2282041		
Estimate Number	11179		Drawing Number	D2282 REV E		
P.O. Number			Project Number	N/A		
This Issue	23/04/2009	S.O. No.	Drawing Revision	E		
Prsht Rev.	NC		Material			
First Issue	/ /	Type	Due Date	30/04/2009	Qty:	60
Previous Run	46369		Um:	Each		
Written By						
Checked & Approved By	JL 09.04.23					
Comment	Est Rev:A		Removed from 9 Digit	05-12-02	JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:	
1.0	D22823	Tube	
		Comment: Qty.: 1.0000 Each(s)/Unit Total: 60.0000 Each(s)	
		Pick:	
	Qty Part Number	Description Batch	
	1 D2282-3	Handle tube <u>B46408</u> = 60x	
			SP 09.05.07
2.0	D22825	Tube	
		Comment: Qty.: 1.0000 Each(s)/Unit Total: 60.0000 Each(s)	
		Pick:	
	Qty Part Number	Description Batch	
	1 D2282-5	Handle tube <u>B46409</u> = 60x	SP 09.05.07
3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	

Comment: LARGE FABRICATION RESOURCE 1

- 1-Weld as per D2282-041 'T' Handle Assembly
- Grind chamfers and ensure full penetration as per dwg D2282
- *****brush weld right after welding, to take color off*****

(Locx)

A/R ER316L SS Filling Rod M102415 - M102421
 Dwg Rev: E

SP 09.05.11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

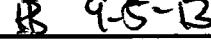
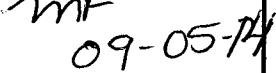
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: "T" HANDLE ASSEMBLY
Job Number: 47406A		Part Number: D2282041
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
4.0	QC9 	VISUAL WELDING INSPECTION 
Comment: VISUAL WELDING INSPECTION		<i>pplog.05.012</i> 
5.0	SMALL FAB 1 	SMALL & MEDIUM FAB RESOURCE 1 
Comment: SMALL & MEDIUM FAB RESOURCE 1		
Tumble 		
6.0	QC5 	INSPECT WORK TO CURRENT STEP 
Comment: INSPECT WORK TO CURRENT STEP		<i>S 09/05/14</i> 
7.0	PACKAGING 1 	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <i>ST 261</i>		<i>09-05-14</i> 
8.0	QC21 	FINAL INSPECTION/W/O RELEASE 
Comment: FINAL INSPECTION/W/O RELEASE		<i>09/05/14</i> 
Job Completion 		<i>MF</i> 

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

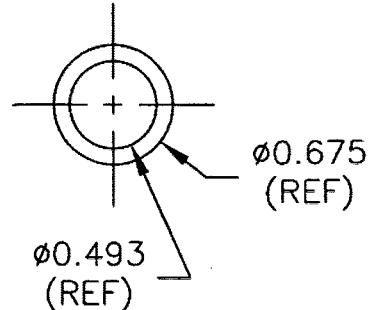
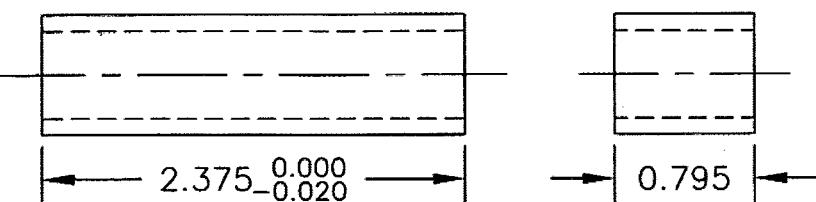
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN BW	DRAWN BY <i>TP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>IP</i>	APPROVED <i>100%</i>	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1
A	94.10.14	NEW ISSUE	
B	95.03.23	RE-DESIGN	
C	97.10.20	CORRECTED NUMBERING SCHEME	
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750	
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030	

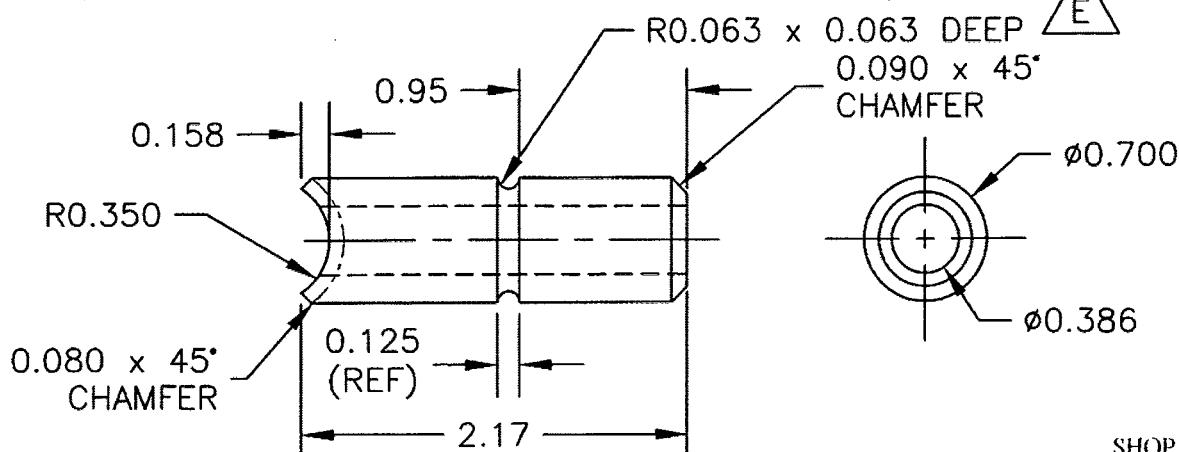
RELEASED
RE-DESIGN
BS/09/16

D2282-3

D

D2282-7D2282-3/-7 TUBE:

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D

D2282-5D2282-5 STEM:

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

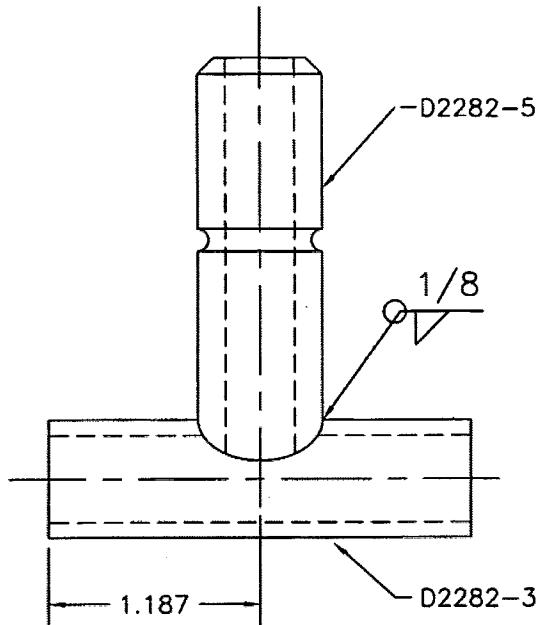
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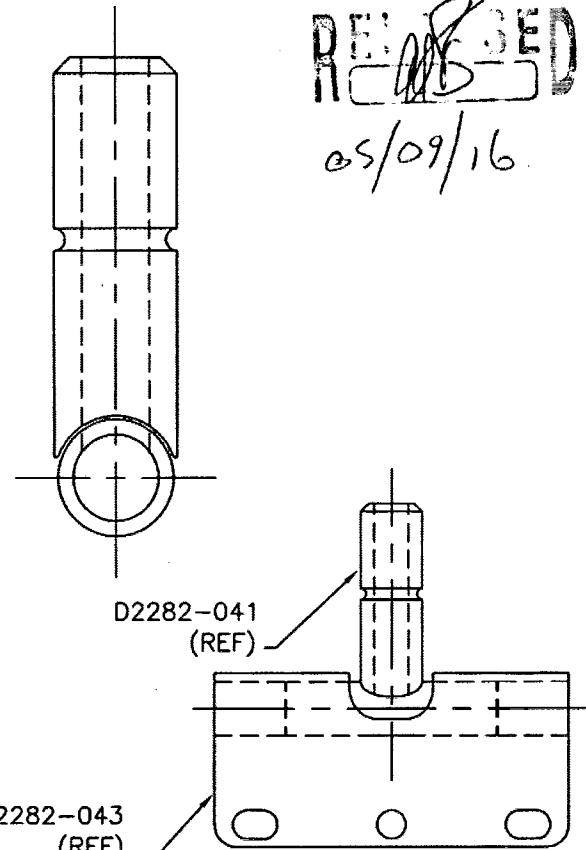
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DART

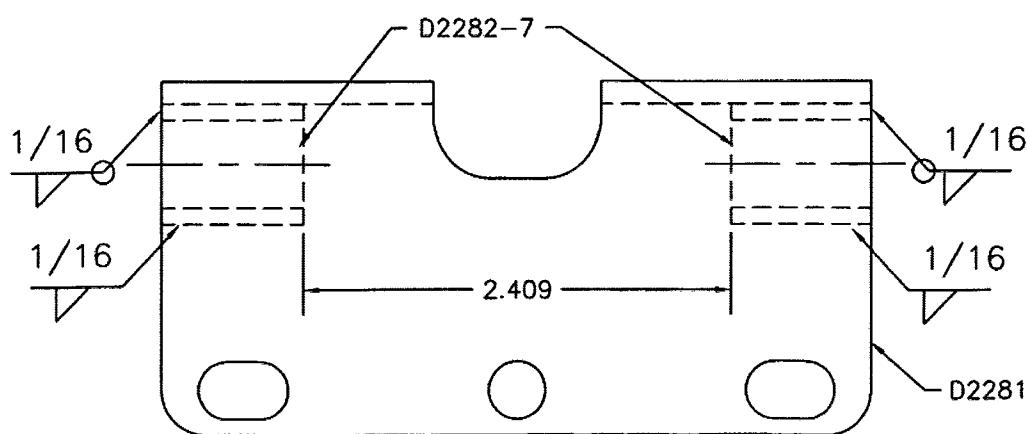
DESIGN BW	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>UP</i>	APPROVED <i>AB</i>	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1



D2282-041 'T' ASSEMBLY
WELD ASSEMBLY PER DART QSI 004



GENERAL ASSEMBLY
SCALE 1:2



D2282-043 SADDLE ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

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